

28+50

## Work Order ID 84083

\*84083\*

Page 1

Wednesday, May 02, 2012 1:07:53 PM

Item ID: D3875-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Floor Protector

Start Date: 5/2/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan: RDate: 1205-2

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3875	Rev A								

100

0.00

\*100\*

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

2

BB 12/05/10

105

0.00

\*105\*

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp:

240

Time IN:

4:30

Time OUT:

7:00

BB 12/05/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*84083\***

Wednesday, May 02, 2012 1:07:53 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 5/2/2012      **Start Qty:** 2.00

\*?\*

**Cust Item ID:**

**Required Date: 5/8/2012      Req'd Qty: 2.00**

\*~\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

110

0.00

**\*110\***

0.00

### Thermoform

### Thermoforming Machine

## Memo

### 1-Machine Set-Up

2-Fre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA0xx using tool DT9435

Dwg Rev:

Folio Rev: \_\_\_\_\_

120

QC2- Inspect parts off machine FAI/FAIB

0,00

**\*120\***

0.00

QC

### Quality Control

## Memo

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check

0.00

**\*130\***

0.00

OC

## Quality Control

## Memo

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, May 02, 2012 1:07:53 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Customer:**

**Start Date:** 5/2/2012      **Start Qty:** 2.00      **\*2\***

**Required Date:** 5/8/2012      **Req'd Qty:** 2.00      **\*?\***

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.00

**\*140\***

0.00

HandThermo

## Memo

### Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

0.00

**\*150\***

0.00

QC

## Memo

## Quality Control

Complete FAI document

0.00

**\*160\***

0.00

QC

## Memo

### Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 84083****\*84083\***

Page 4

Wednesday, May 02, 2012 1:07:53 PM

Item ID: D3875-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Protector

Start Date: 5/2/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

(2) 12/5/14

12/5/15

mk 12-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, May 02, 2012 1:07:58 PM

Page 1

Work Order ID: 84083

\*84083\*

Parent Item: D3875-1

\*D3875-1\*

Parent Item Name: Floor Protector

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 09.02.06 New Issue DL  
Add Step 105 Dry Material 10/04/21 DL

IPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased				100	sf	1,290.266	9.84	19.68			

\*MI FXS 118-90318-08\*

Lexan Sheet

\*\*

Location

therm

113127

Loc Qty

1290.266941

1290.26694

Loc Code

19.68 sq ft.

12/05/14

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 841083
<b>Description:</b> Floor Protector		<b>Part Number:</b> D3875-1
<b>Inspection Dwg:</b> D3875	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: TS

Date: 12/05/14

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	1.07	✓			
0.080	Min	1.085	✓			
45.2	+/-0.100	45.3	✓			
21.8	+/-0.100	21.75	✓			
1.4	+/-0.100	1.417	✓			

Measured by: TS

Date: 12/05/14

Audited by: OK

Date: 12/05/14

Prototype Approval:

N/A

Date:

N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>TS</u>

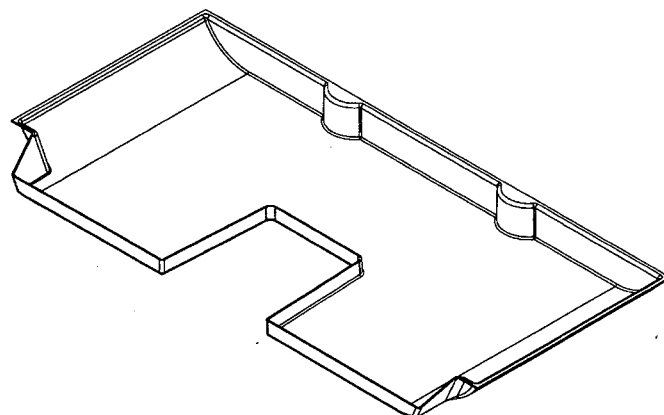
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3875-1 FLOOR PROTECTOR (206B)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84083  
*0812052*

**RELEASED**  
*09/05/05*

**NOTES:**

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9475 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AK</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AK</i>		
CHECKED	<i>LS</i>	DRAWING NO. <b>D3875</b>	REV. A
MFG. APPR.	<i>AK</i>	SHEET 1 OF 2	
APPROVED	<i>AK</i>	TITLE	SCALE
DE APPR.	<i>AK</i>	<b>FLOOR PROTECTOR (206B)</b>	NTS
DATE	<b>09.01.29</b>	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

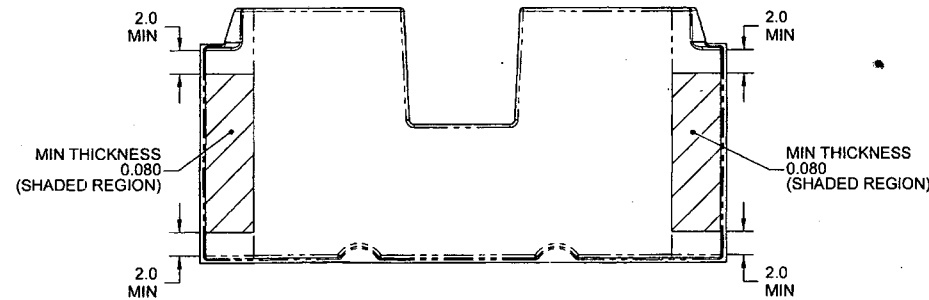
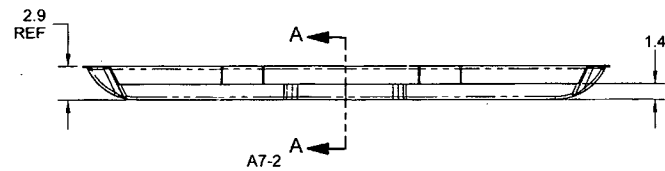
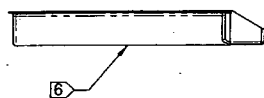
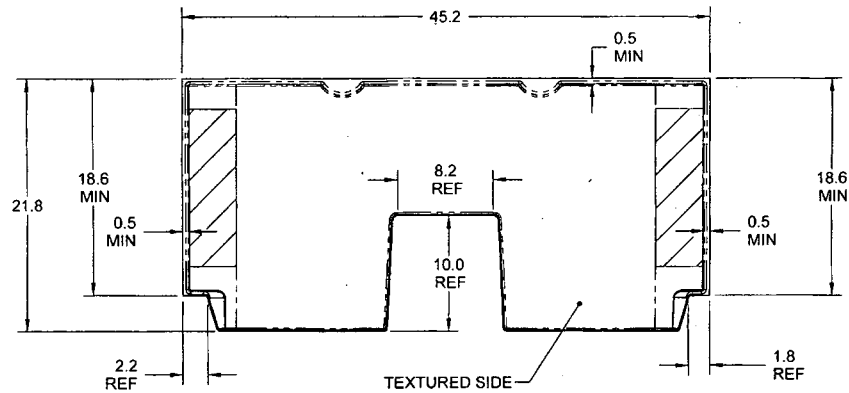
C

B

B

A

A



**SECTION A-A** B4-2

**D3875-1 FLOOR PROTECTOR (206B)**

240 83

**RELEASED**  
29/05/05

DESIGN	Ref	<b>DART AEROSPACE LTD</b>	
DRAWN	Ref	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Ref	DRAWING NO. <b>D3875</b>	REV. A
MFG. APPR.	Ref	TITLE	SHEET 2 OF 2
APPROVED	Ref	<b>FLOOR PROTECTOR (206B)</b>	SCALE
DE APPR.	Ref		NTS
DATE	09.01.29	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

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